

DART AEROSPACE LTD		Work Order:	21965
Description:	D3307-041 Access panel	Part Number:	D3307-041
Dwg:		Qty:	2
		Page 1 of 1	

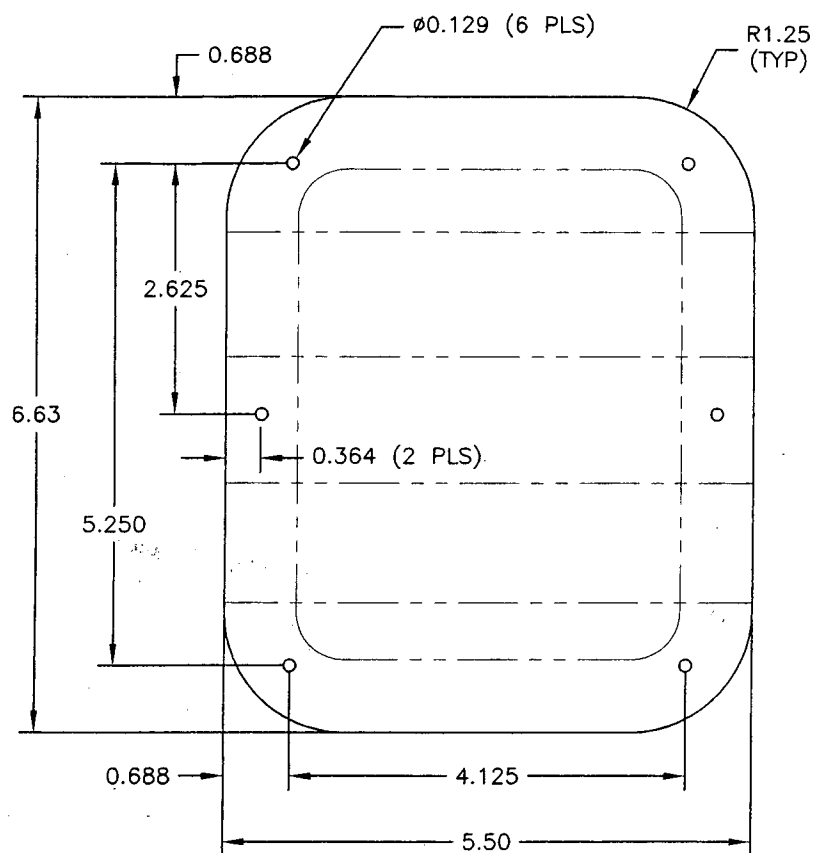
Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JF	04.11.24	2
2a	GA	Cut blank size as per Dwg D3307-1 M14883 (40)	JB	04.11.24	2
2b	GA	Drill holes as per Dwg 3307-1	JB	04.11.24	2
3	GA	Band using DT 8745	JB	04.11.24	2
4	GA	Deburr	JB	04.11.24	2
5	GA	Cut Gasket as per Dwg 3307-3 using D3245 D20774 ^{1345P used}	JB	04.11.24	2
6	GA	Band Gasket using AR 1300/1300 M15604	JB	04.11.24	2
7	GA	Transfer drill holes through gasket	JB	04.11.24	2
8	QCS	Inspect level 5	RT	04.12.01	2
9	ST	Identify & stock	JB	04.12.01	2
10	AC	1.31 Cost/Pack: 1.87	Sac	08-01-07	2
11	DC	Close W/O Inspect level 21	JF	05.01.12	2

Rev	Date	Change	Revised By	Approved
A		New issue		

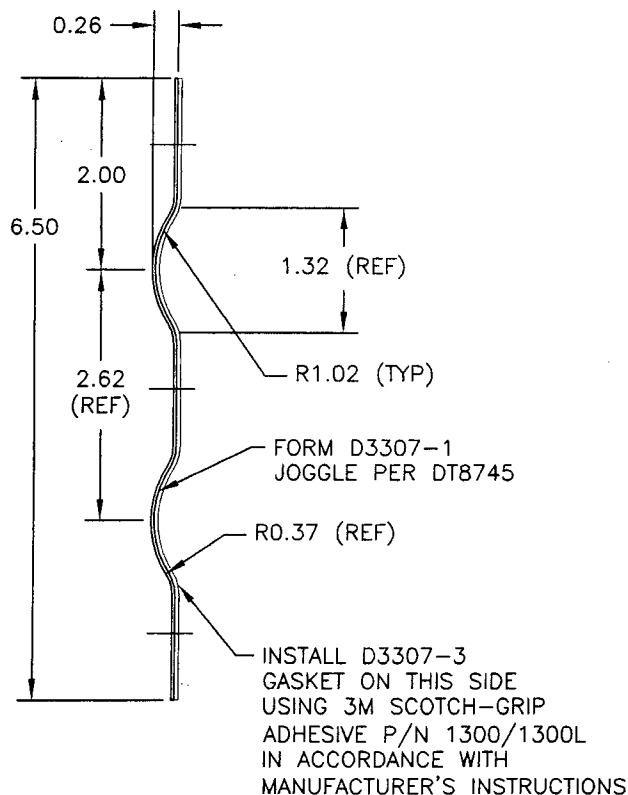


DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3307	REV. A SHEET 1 OF 2
DATE 04.09.23		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:2
A	04.09.23	NEW ISSUE	

M14883



D3307-1 PANEL FLAT PATTERN



D3307-041 BEND DETAIL

IDENTIFY WITH P/N & B/N
USING FINE POINT
PERMANENT MARKER

D3307-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK ANNEALED (REF. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

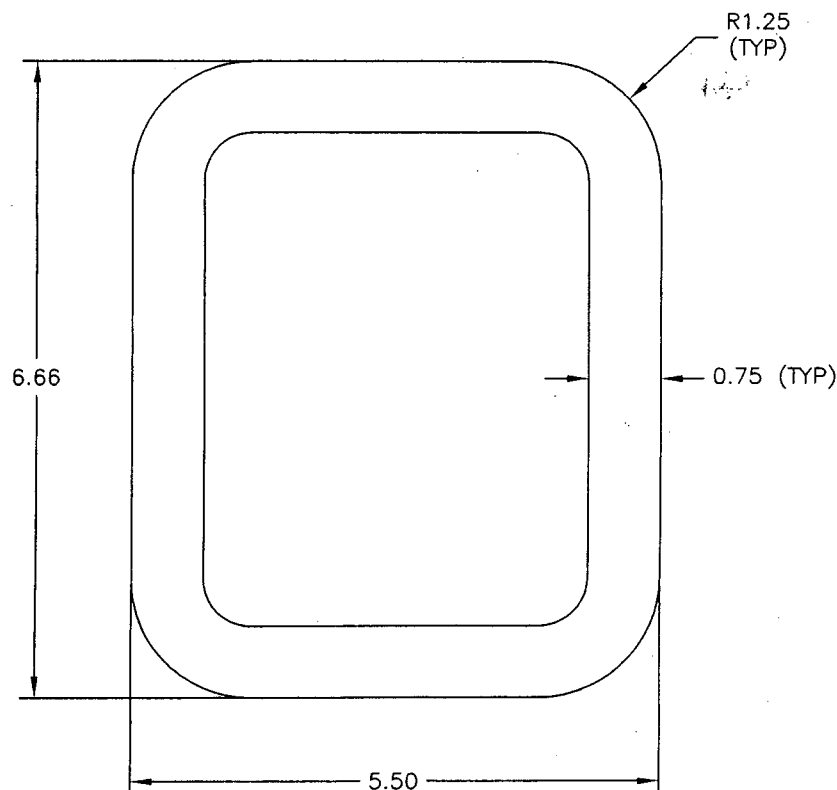
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3307	REV. A SHEET 2 OF 2
DATE 04.09.23		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:2



D3307-3 GASKET

D3307-3 NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET 0.035 THICK MIL-A-7021C OR MIL-A-17472B (CLASS 1 & 2) OR MIL-G-12803A (GRADE P-1161A)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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